

Work Order ID 53499

November 6, 2009 11:16:24 AM



Page 1

Item ID: D3929-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gusset Assembly

Start Date: 06/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: PPDate: 9-11-10

Tooling:

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3929

Dwg Rev: AProg Rev: A

2-Deburr if necessary

AB 9-11-10

(7)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

AB 9-11-10

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Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

ml 09 11 10 (7)

130



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

Pl 09 11 11

140



Large Fab

Large Fab

Memo

Weld bushings D3907-1 as per dwg D3929

0.00

0.00

316L rod batch: *m109213*

Pl 09 11 11

(7)

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Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.11.11

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

PD 09.11.11

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Basket
CELL

Cpl 09 11 11

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Accept



Setup Start



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Stop



Item Name: Gusset Assembly

Start Date: 06/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/12 *[Signature]*

mf
09-11-12

Picklist Print

November 6, 2009 11:16:28 AM

Page 1

Work Order ID: 53499

Parent Item: D3929-041RevA

Parent Item Name: Gusset Assembly



Comments:

Start Date: 06/11/2009

Required Date: 13/11/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	132.1100	2.8421	3.4		
												18 9-11-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	132.1099979	
111018	4.10999789	
112663	128	

D3907-1RevA

Manufactured No



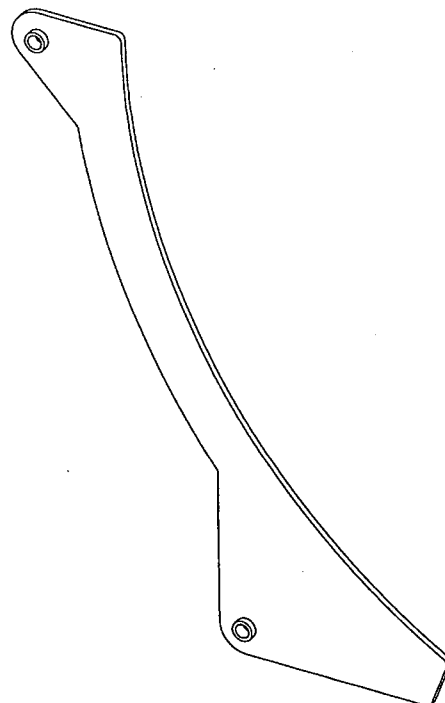
Bushing

130 Each 41.0000 12.0000

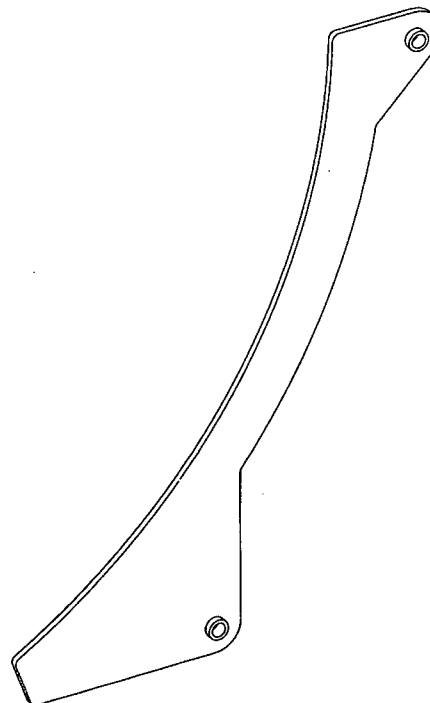
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	41	
51475	1	
53138	40	

⑦
111018
Pl 09.11.11
✓
①
② ③

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53499

11-6

RELEASED
07/04/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929** REV. A

SHEET 1 OF 3

TITLE **GUSSET ASSEMBLY** SCALE NTS

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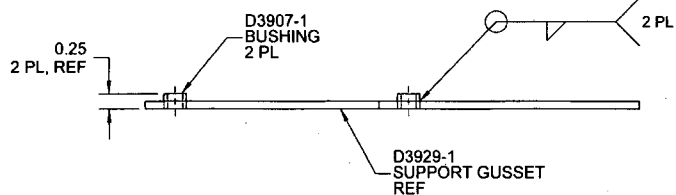
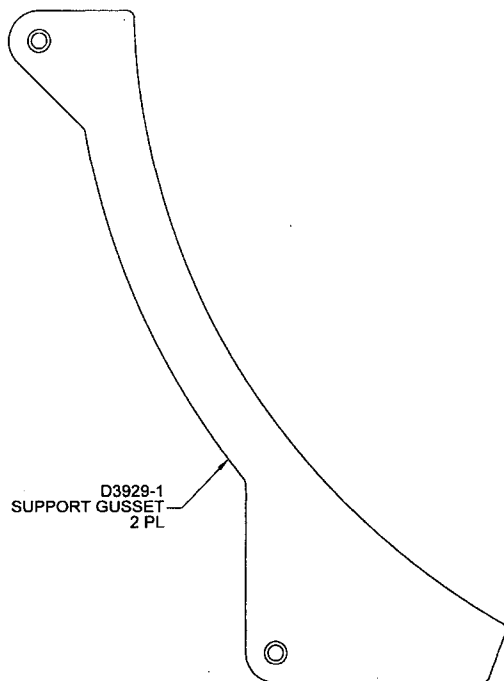
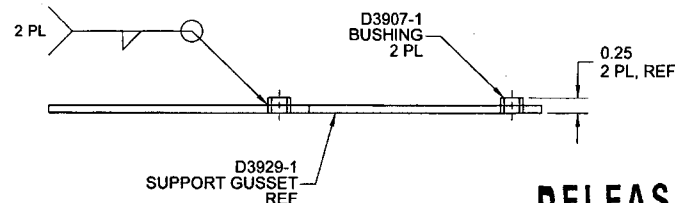
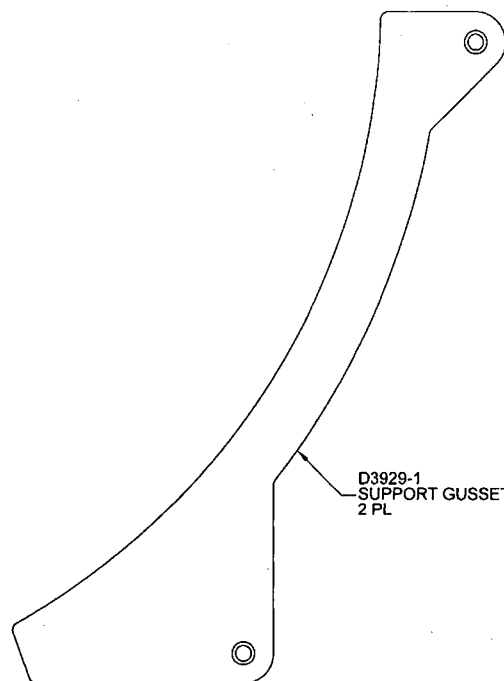
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C

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A

**D3929-041 GUSSET ASSEMBLY****D3929-042 GUSSET ASSEMBLY****RELEASED**09/04/22 MB
111053499

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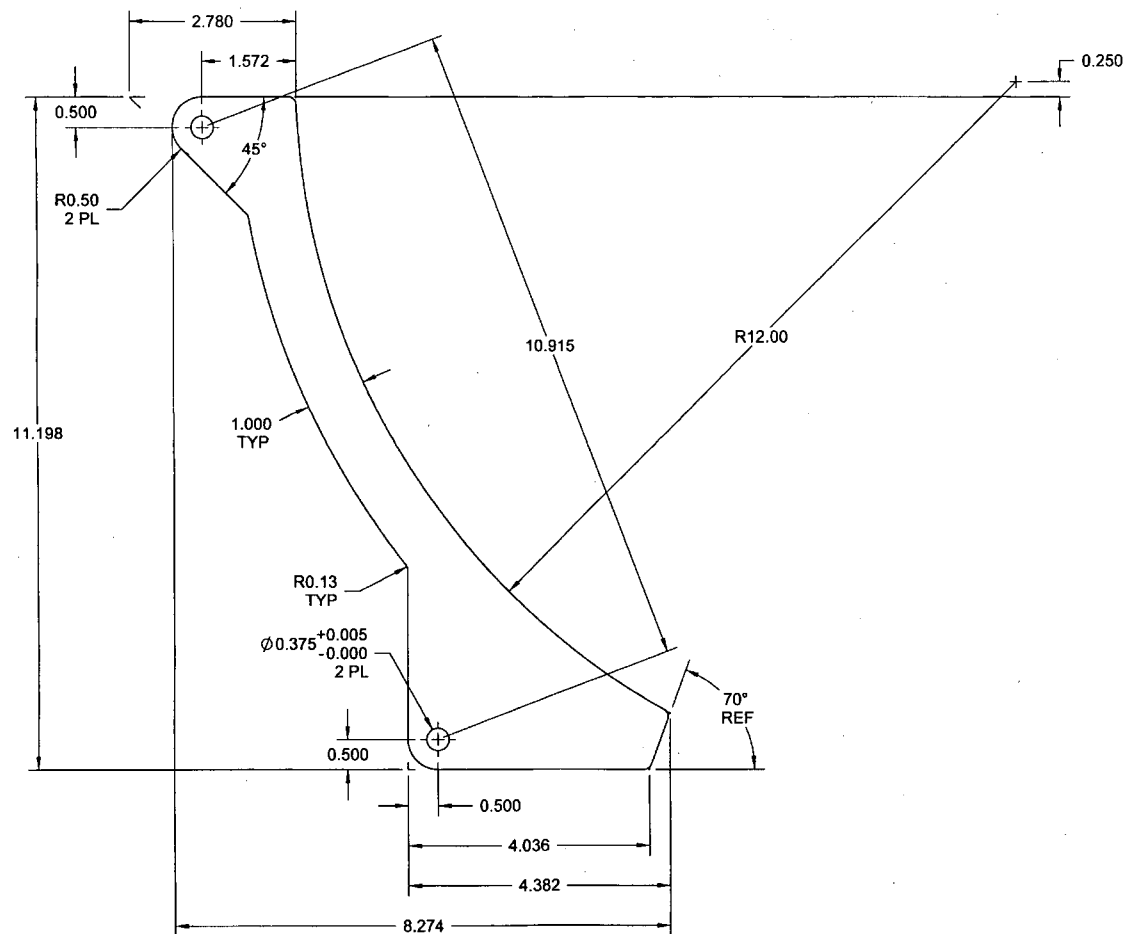
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2

1



D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

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